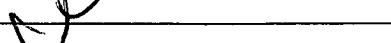


Date: Monday, 28/05/2007 9:08:16 AM
 User: Linda Lacelle

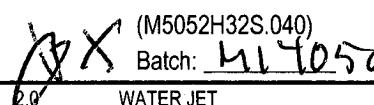
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET LOCATOR		
Job Number	: 31923		Part Number	: D23693		
Estimate Number	: 11230		Drawing Number	: D2369 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 28/05/2007 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 05/06/2007 Qty: 10 Um: Each		
Previous Run	: 31923					
Written By	: 					
Checked & Approved By	: 					
Comment	Est Rev A	Removed from 9 Digit 05-12-05 JLM				
	Est Rev:B	Now on Waterjet 07-05-28 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
Comment: Qty.: 1.4217 sf(s)/Unit Total: 14.2170 sf(s) Material: 5052-H34 or H32 0.040" thick (M5052H32S.040) Batch:  SAD 07/05/31		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET SAD 07/05/31		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/05/31		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 28/05/07 + 10		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 28-1-7
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr 28/05/07 10		
6.0	QC5	INSPECT WORK TO CURRENT STEP 28/05/07 10
Comment: INSPECT WORK TO CURRENT STEP 28/05/07 10		

Date: Monday, 28/05/2007 9:08:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 178

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007.1.17

W

PPD

Date: Tuesday, 4/17/2007 3:56:20 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BRACKET LOCATOR	
Job Number	31923				
Estimate Number	11230				
P.O. Number	:		Part Number	D23693	
This Issue	4/17/2007	S.O. No. :	Drawing Number	D2369 REV A	
Prsht Rev.	NC		Project Number	N/A	
First Issue	11	Type : MACHINED PARTS	Drawing Revision	A	
Previous Run	:		Material	:	
Written By	:		Due Date	5/2/2007 Qty: 10 Um: Each	
Checked & Approved By	KJ 07.04.18				
Comment	Est Rev A		Removed from 9 Digit	05-12-05	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
2.0	SHEAR	SHEAR
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: Qty.: 1.4217 sf(s)/Unit Total : 14.2170 sf(s)
 Material: 5052-H34 or H32 .040" thick
 (M5052H32S.040)
 Batch: _____

Comment: SHEAR
 Cut blanks: 39.0" x 5.00

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D2369-3 as per Folio D2369-3 and Dwg D2369

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Comment: SECOND CHECK

Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

PTD

10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/31	2.0	hole's on Part were to big had to change the offset E.C. Human error	Initial Chief Eng as1012	Scrap - replace Qty 1 part	SAM 07/05/31	Si 07/06/18	as1012	EP 07/06/18
07/05/31	2.0 2.0	coring mat. was used 0.058" thick instead of 0.040" mat.	Initial Chief Eng as1012	Parts are acceptable	SAM 08/01/07	as 08	as1012	✓
		E.C. Human error						

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31923
Description: Deck Plate Locator Bracket	Part Number:	D2369-3
Inspection Dwg: D2369	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	S49	Audited by:	S49	Prototype Approval:	N/A
Date:	07/05/31	Date:	04/06/18	Date:	N/A

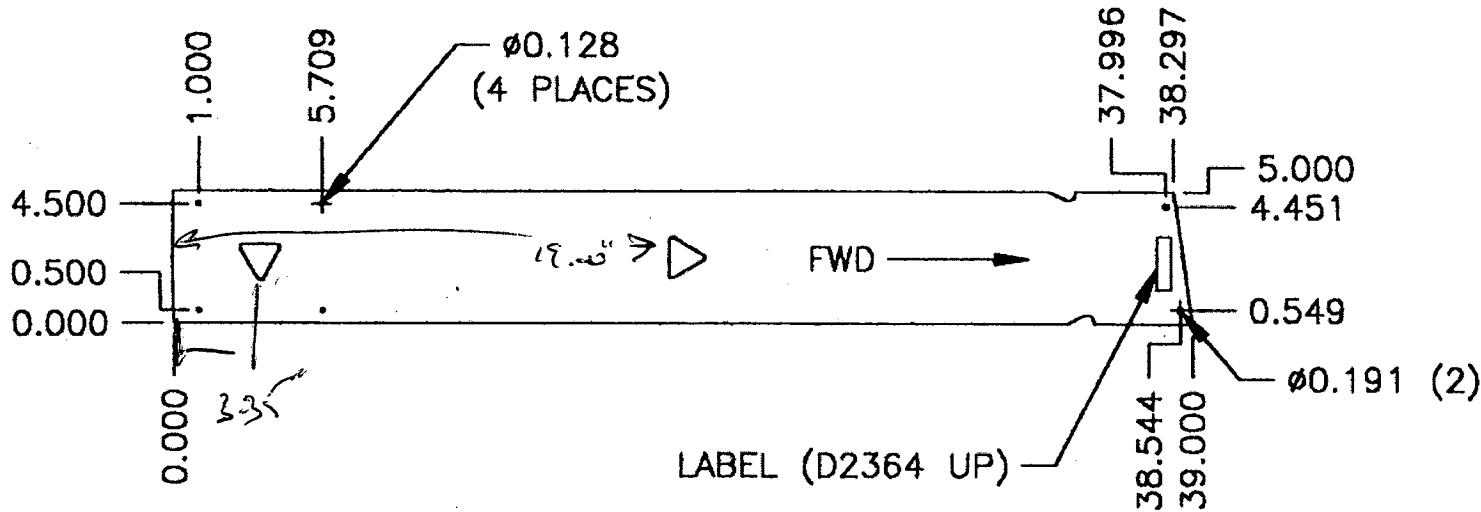
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	SJF

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96 06 10

96 06 10

DART

DESIGN		DART AEROSPACE LTD	
		VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS		DRAWN BY	
B WILLIAMS		APPROVED	
B WILLIAMS		DRAWING NO.	REV. A
B WILLIAMS		D2369	SHEET 1 OF 2
DATE		TITLE	SCALE
95:02:20		DECK PLATE LOCATOR BRACKET	1:7



D2369-1

MATERIAL: 5052-H34 0.040 THICK

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31923

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B. WILLIAMS	B. WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>[Signature]</i>	<i>[Signature]</i>	D2369	SHEET 2 OF 2
DATE	95:02:20	TITLE	SCALE
		DECK PLATE LOCATOR BRACKETS	1:7



DART

RELEASED
06/06/96

MATERIAL: 5052-H34 0.040 THICK

D2369-3

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WITHOUT NOTICE
WORK ORDER
NO. 31923

